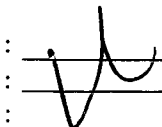


Date: Monday, 04/05/2009 3:39:36 PM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---|------------------|------------------------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name | : D350-748-101UP |
| Job Number | : 47730 | | |
| Estimate Number | : 10804 | | |
| P.O. Number | : | Part Number | : D350748101 |
| This Issue | : 04/05/2009 S.O. No. : | Drawing Number | : PAINT |
| Prsht Rev. | : NC | Project Number | : |
| First Issue | : / / Type : CROSSTUBES | Drawing Revision | : |
| Previous Run | : 00015 | Material | : |
| Written By | :  | Due Date | : 11/05/2009 Qty: 1 Um: Each |
| Checked & Approved By | : | | |
| Comment | : | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|----------------|
| 1.0 | SPRAY PAINTING | SPRAY PAINTING |
|-----|----------------|----------------|



Comment: SPRAY PAINTING
 PULL FROM STOCK:

1 X D350-748-101UP B 44433 CHG 001

DISASSEMBLE AND KEEP STK
 TO REASSEMBLE AFTER PAINT

SPRAY PAINT PER QSI005

LI
 ml 09.05.13 ①

| | | |
|-----|--------------|--|
| 2.0 | D350748101UP | Crosstube Installation, High Fwd-UNPAINT |
|-----|--------------|--|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Installation, High Fwd-UNPAINT

| | | |
|-----|------|---------------------|
| 3.0 | QC14 | INSPECT SPRAY PAINT |
|-----|------|---------------------|



Comment: INSPECT SPRAY PAINT

45 09-05-14

| | | |
|-----|------------|-----------------------|
| 4.0 | CROSSTUBES | CROSSTUBES RESOURCE 1 |
|-----|------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

Clamp: M821920-20 B:110451 x1

1-Install Ground wire Insert, then insert screw and washer

B:46437

2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 09 05 14 ①

Date: Monday, 04/05/2009 3:39:36 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-748-101UP

Job Number: 47730

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



2005.19 ①



Comment: INSPECT WORK TO CURRENT STEP

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



** Ensure to remove the original red decal from the k.t. : A new label is made. **



Comment: INSPECT 100% KITS FOR COMPLETENESS
ENSURE ORIGINAL KIT WITH CROSSTUBE

See 5/21

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE USING NEW B/N
NEW LABELS REQUIRED

*CHG001
JUN 09.05.20 ①*

9/5/20

1K

54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20

Job Completion



MF 09-05-25

| | | | |
|--|--|--------------------|--|
| DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ON, CANADA K6A 1K7 | | | |
| P.N | | D350-748-101 UP | |
| DESC | | Crosstube Fwd High | |
| LOT | | B44433 | |
| MODEL | | AS350/355 | |
| CHG | | CHG001 | |
| STC | | SH06-27 | |
| STC | | SR02359NY | |
| STC | | | |
| MADE IN CANADA | | | |
| D2729-1 | | | |



| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>qp</i> | DRAWN BY <i>qp</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>HA</i> | APPROVED <i>HA</i> | DRAWING NO. D350-748-141 | REV. D SHEET 1 OF 3 |
| DATE 06.10.31 | | TITLE CROSSTUBE (AS 350/355 HI FWD) | SCALE NTS |
| A | 06.03.31 | NEW ISSUE | |
| B | 06.06.30 | ADD D6017-115 & PRIME AND PAINT | |
| C | 06.08.14 | ADD CAD PLATING | |
| D | 06.10.31 | MAG. PARTICLE AND CAD PLATE AS MFD. | |

RELEASED
06.10.31 *HA*

| QTY | P/N | DESCRIPTION |
|-----|---------------|--|
| X | D350-748-141 | CROSSTUBE ASSEMBLY (AS 350/355 HI FWD) |
| 1 | D6017-115 | CROSSTUBE (OR D6015-125) |
| 2 | D3502-1 | SUPPORT |
| 2 | D2856-400-710 | ABRASION STRIP |
| 1 | AELS-1032-225 | INSERT |
| 1 | AN960JD10 | WASHER |
| 2 | MS21920-20 | CLAMP (PER DART SPEC. M-MS21920-20) |
| 1 | MS27039-1-10 | SCREW |

UNDER REVIEW

09.02.05
PER PCR #09.001

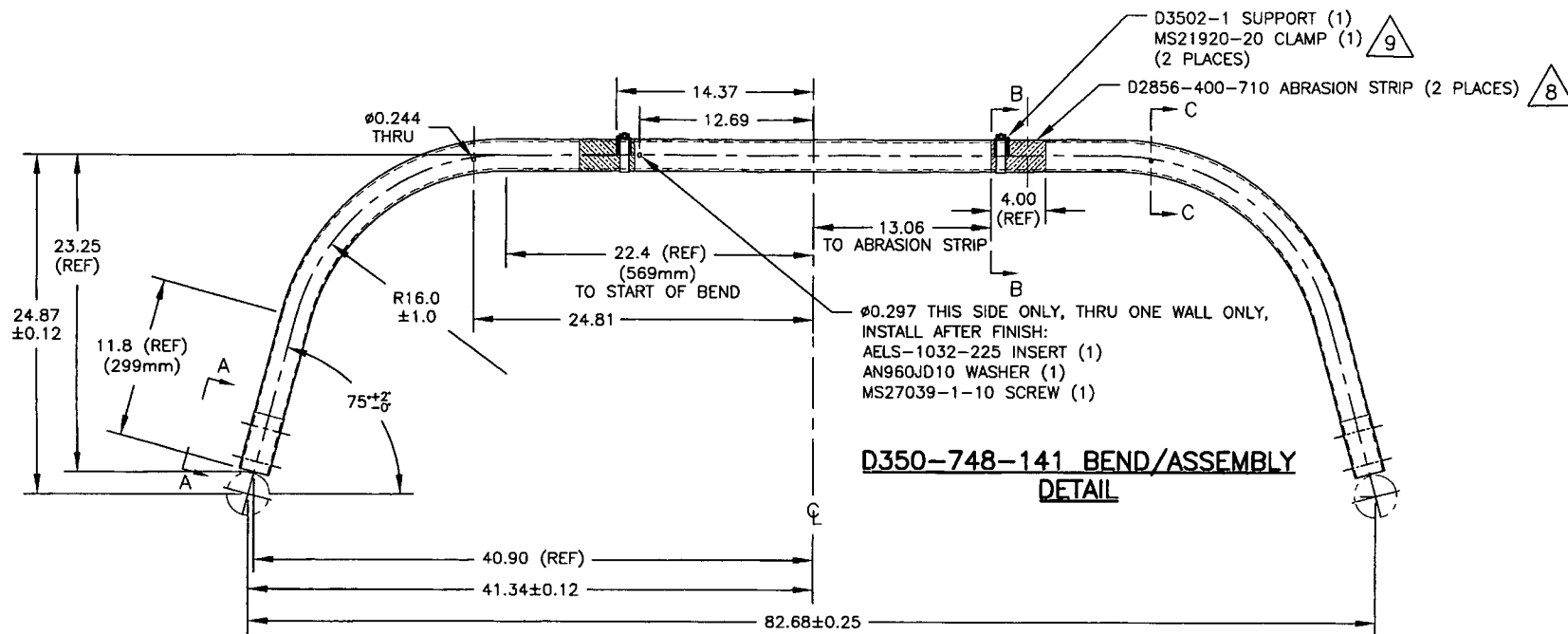
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

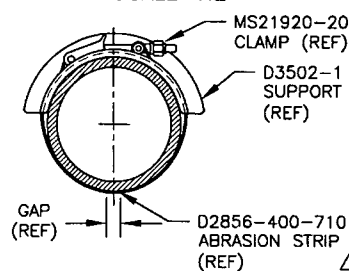
OK 07.10.22

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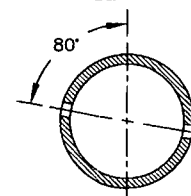
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SECTION B-B
SCALE 1:2



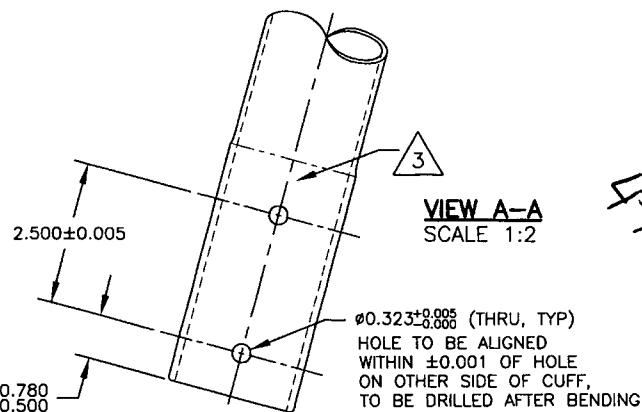
SECTION C-C
SCALE 1:2



UNDER REVIEW
09.02.05

UNDER REVIEW
09.16.05

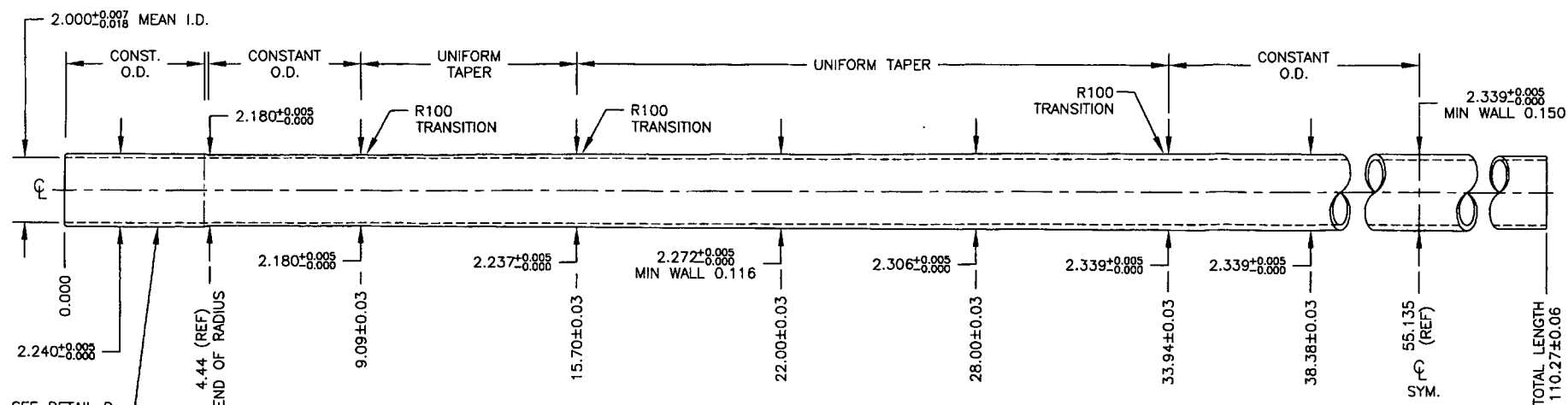
RELEASED
06.10.31



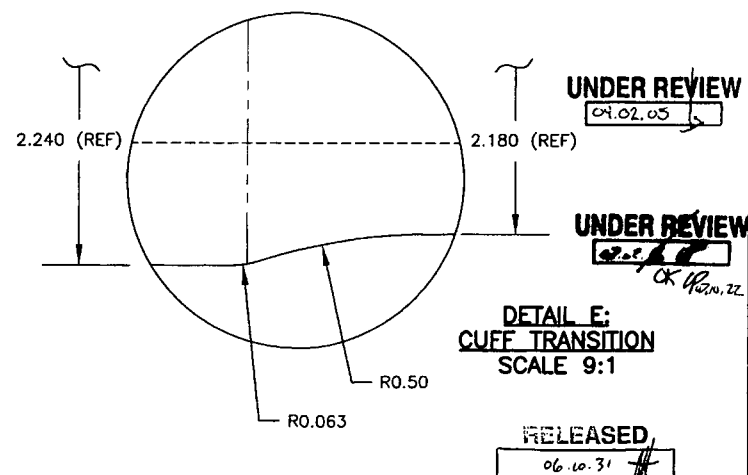
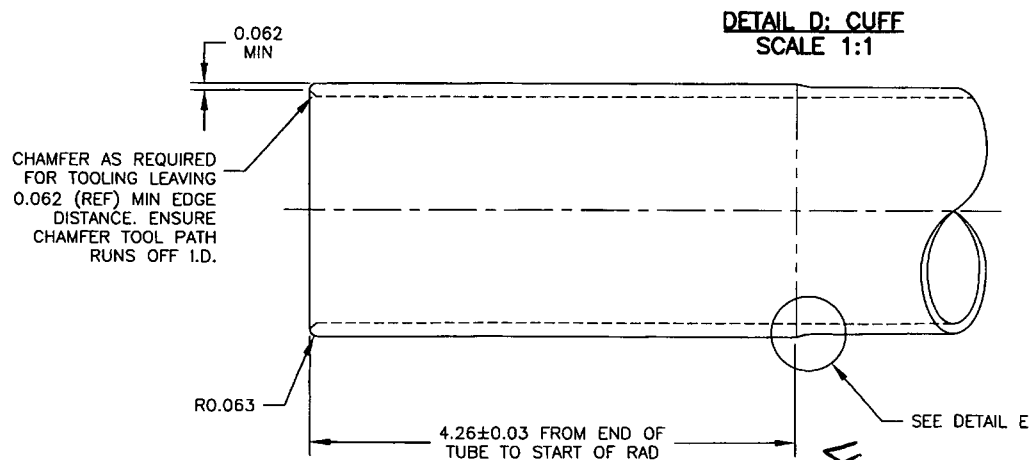
47730

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| | | | | | |
|---------|----------|----------|-------------------------------|--------------|--|
| DESIGN | q | DRAWN BY | q | DART | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. | REV. D |
| DATE | 06.10.31 | TITLE | CROSSTUBE (AS 350/355 HI FWD) | D350-748-141 | SHEET 2 OF 3 |
| | | SCALE | 1:8 | | |



D350-748-141 MACHINING DETAIL



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| | | | |
|------------------|--|-----------------------------|--|
| DESIGN qp | DRAWN BY qp | DART | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| CHECKED # | APPROVED # | DRAWING NO. D350-748-141 | REV. D SHEET 3 OF 3 |
| DATE 06.10.31 | TITLE CROSSTUBE (AS 350/355 HI FWD) | SCALE 1:3 | |